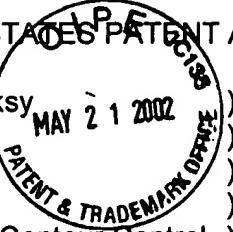


#9  
page  
5-28-02

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: Henryk Oleksy  
Application No. 09/477,858  
For: Process for Contour Control  
Machining of Metal Blocks  
Filed On: January 5, 2000



Group Art Unit: 2125  
Examiner: Alexander J. Kosowski

RECEIVED

MAY 24 2002

Technology Center 2100

Assistant Commissioner For Patents  
Box: Non-Fee Amendment  
Washington, D.C. 20231

Please amend the application as follows:

IN THE SPECIFICATION

1. Please amend page 1, line 24, as follows (changes from previous version to the rewritten version are shown in Appendix A where underlines indicate the additions and brackets indicate the deletions):

Presently, the method of preparing these root sections of a turbine blade with the many successive machining operations requires separate tolerance measurements, separate machining operations and multiple set-ups. The instant invention has been devised with the view to substantially eliminating the many separate procedures inherent in the prior art of machining root sections of turbine blades and has as its essential object an improved method for machining the root section of turbine blades on a vertical or horizontal machining center with rotary table.

2. Please amend page 2, line 43, as follows (changes from previous version to the rewritten version are shown in Appendix A where underlines indicate the additions and brackets indicate the deletions):

Sub A3

The root section of the turbine blade is designed to fit within precise tolerances upon a circular rotor. Because of the curvatures of the mating surface of the root section of the turbine blade and the mating section of the circular rotor, the machining of the root section of the turbine blade requires convex movements of the form cutter tool (9) and the rotating of the rotary table (7) which holds the root section of the turbine blades. The form cutter (9) travels on a convex line (center line, See Figure 5) from point A to point L following convex path (E+R), the form cutter spins and the rotary table simultaneously rotates from angle  $-Q^\circ$  to angle  $+Q^\circ$ , (See Figure 5) this operation can be also approached at point L and finished at point A.